

Work Order ID 52910

October 19, 2009 12:43:41 PM

Page 1

Item ID: D2571

Accept

Revision ID: E

Item Name: Saddle, Fwd Out 205

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 6.00

Required Date: 11/02/09 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2571

Rev E

100

0.00

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 52910 Double check by: HA ☐ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets ☐ 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3 per Folio FA051 and inspect

110

0.00

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

120

0.00

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Work Order ID 52910

October 19, 2009 12:43:41 PM

Page 2

Item ID: D2571

Accept

Revision ID: E

Item Name: Saddle, Fwd Out 205

Start Date: 10/19/09 Start Qty: 6.00

Required Date: 11/02/09 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:30am

M112260

FINISH TIME:

OVEN TEMPERATURE:

320°

10/10/26

10-27

10/10/27

10

10

10

Work Order ID 52910

October 19, 2009 12:43:41 PM

Page 3

Item ID: D2571

Accept

Revision ID: E

Item Name: Saddle, Fwd Out 205

Start Date: 10/19/09 Start Qty: 6.00

Required Date: 11/02/09 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control



BL 09-10-27

10

433

9/10/28

100 SE

09/10/29

BL 09-10-28

Picklist Print

October 19, 2009 12:43:45 PM

Page 1

Work Order ID: 52910

Parent Item: D2571RevE

Parent Item Name: Saddle, Fwd Out 205


Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007RevB		Manufactured	No			100	Each	0.0000	6.0000			
												
Saddle Billet												

Batch # B46412

mk 09/10/21

10

DART AEROSPACE LTD	Work Order: 52910
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.439	.440	.440		
B	1.745	1.755		1.749	1.749	1.750	1.750		
C	3.495	3.505		3.499	3.499	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.000	8.000		
F	0.490	0.510		.503	.503	.502	.503		
G	0.257	0.262		.259	.259	.259	.260		
H	0.375	0.380		.377	.377	.377	.378		
I	0.490	0.510		.501	.501	.502	.499		
J	1.174	1.184		1.178	1.178	1.177	1.178		
K	0.558	0.578		.566	.567	.567	.565		
L	1.174	1.184		1.177	1.178	1.177	1.178		
M	1.490	1.500		1.493	1.494	1.494	1.495		
N	2.495	2.505		2.499	2.499	2.499	2.499		
O	3.869	3.879		3.873	3.873	3.874	3.874		
P	0.115	0.135		.124	.122	.122	.129		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.249	.257		
S	0.115	0.135		.128	.131	.132	.133		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.959	2.959	2.959	2.860		
V	0.230	0.250		.236	.239	.238	.237		
W	0.115	0.135		.115	.117	.116	.127		
X	0.308	0.313		.312	.312	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.633	.623	.623	.621		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.243	.247	.247	.246		
AE	1.375	1.395		1.389	1.387	1.387	1.389		
AF	0.115	0.135		.135	.135	.133	.135		
AG	0.240	0.280		.250	.260	.250	.248		
AH	0.240	0.260		.246	.249	.248	.247		
AI	2.000	2.020		2.002	2.000	2.000	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	RF
Date:	09/10/21

Audited by:	SA
Date:	09/10/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Fwd Outboard		Part Number: D2571	
Inspection Dwg: D2571 Rev. E		Page 1 of 1	

2043

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				51	62	72	82		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	.501	.503	.503		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.492	.498	.500	.500		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.500	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.126	.128	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.250	.252	.251		
S	0.115	0.135		.125	.130	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.961	2.962	2.961		
V	0.230	0.250		.238	.239	.238	.239		
W	0.115	0.135		.125	.125	.125	.127		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.336	1.336	1.334	1.335		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.250	.243	.249		
AI	2.000	2.020		2.001	2.002	2.002	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <u>SP</u>
Date: <u>09/10/22</u>

Audited by: <u>SA</u>
Date: <u>09/10/26</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1	

30f3

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.504	.508				
G	0.257	0.262		.259	.259				
H	0.375	0.380		.377	.377				
I	0.490	0.510		.500	.500				
J	1.174	1.184		1.130	1.130				
K	0.558	0.578		.570	.570				
L	1.174	1.184		1.180	1.130				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.125	.127				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.248	.251				
S	0.115	0.135		.130	.130				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.238	.238				
W	0.115	0.135		.130	.125				
X	0.308	0.313		.310	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.364	.364				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.630	.630				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.250				
AE	1.375	1.395		1.384	1.385				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.248	.246				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: <i>JS</i>	Audited by: <i>SA</i>
Date: <i>09/10/22</i>	Date: <i>09/10/26</i>

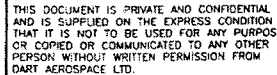
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JS</i>



UNCONTROLLED
SUBJECT TO THE COMMANDMENT
OF THE OFFICE

NO. 52910 BD09-10-15 RELEASED
JUN 17 1964

MATERIAL: 7975-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALQDINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCRP DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. WILLOWBURRY, ONTARIO, CANADA
DS	PH		
CHECKED 	APPROVED 	DRAWING NO. D2571	REV. E SHEET 1 OF 1
DATE 05.07.13		TITLE OUTER FWD SADDLE	SCALE 2:3